

Date: Tuesday, 7/18/2006 2:54:33 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services  
 Job Number : 27957  
 Estimate Number : 10262  
 P.O. Number : N/A  
 This Issue : 7/18/2006 S.O. No. : N/A  
 Prsht Rev. : NC  
 First Issue : N/A Type : LANDING GEAR  
 Previous Run : 27956  
 Written By :  
 Checked & Approved By :  
 Comment : Est Rev: 02-09-25 Rearranged procedure steps KJ  
 Est Rev: 06-03-23 As per Rev D JLM  
 Est Rev: 06-07-13 As per dsi9343 EC

Drawing Name : 350 SKIDTUBE ASSEMBLY LH UNDER REVIEW  
 Part Number : D350636011  
 Drawing Number : D2750 UNDER REVIEW  
 Project Number : N/A  
 Drawing Revision : D  
 Material : N/A  
 Due Date : 8/25/2006  
 Qty: 1 Um: Each

PH  
 6.07.19

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy blue file and type labels per PPP D350-636-011 CHG 002

K-S 06-07-27

2.0 D26003BENT Extrusion Bent



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch  
 1 D2600-3-Bent Extrusion (Bent)

B26787 Pm 06-08-16

3.0 D2744 Fwd Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Cap

Batch: B25839

BE 06-08-16

4.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end

2-Drill pilot holes as per Dwg D2750 sheet 3 (D2750-1 details). Drill using drill Jig DT8150 &amp; DT8863 drilling holes labelled "A" only.

3- Mark fwd end for cutting using Drill Jig DT 8150 &amp; DT8863 and cut as per dwg D2750.

Pm 06-08-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Seq. #:

Machine Or Operation:

Description :

4-Drill pilot holes for Detail B using DT8330

5-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 and open to 0.250" \*\*\*Make sure that wearplate holes are on bottom of tube\*\*\*\*\*

6-Open up holes of Detail A to 0.250" (total of 2 holes per side)

7- Countersink all fwd wearshoe holes (total of 19 holes per side) DO NOT C'SINK THE LAST AFT HOLES (total of 2 per side for blade fitting) as per dwg D2750.

8-Countersink Detail A as per dwg D2750.

9-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004.  
A/R Aluminum Rod

10-Grind welds flush as per Dwg D2750

5.0 QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8.0

D2739

350 I Beam



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Web

Batch: 627967 RT 06-08-13

9.0

D34901

CROSS BOLT SPACER



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Crossbolt spacer

Batch: 327972 BE 06-08-28

W/O:		WORK ORDER CHANGES					
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Drawing Name: 350 SKIDTUBE ASSEMBLY LH UNDER REVIEW

Job Number: 27957

Part Number: D350636011

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

D34903

CROSS BOLT SPACER



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Crossbolt spacer

Batch: 0327973

BE 06-08-28

11.0

D2743

Crossbolt Spacer



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Crossbolt Spacer

Batch: B26208

BE 06-08-28

12.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open up holes for Detail B, "hole size W" and blade fitting location holes to 0.500" (total of 9 holes per side) as per dwg D2750.

2-Open up holes of Detail V & Detail C to 0.625" (total of 8 holes per side) as per dwg D2750.

3-Open up holes of Detail D to 0.750" (total of 4 holes per side) as per dwg D2750.

4-Chamfer holes of Detail V, Detail C, Detail D and hole size "W" per dwg D2750 (welding instructions on sheet 4)

5-Deburr and blow out all chips from inside of tube

6-Bond web D2739 in place as per QSI 015

A/R

Sikaflex-291

batch:

M101855

exp. date: 07-02-01

ET 06-08-13

7- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 4)

A/R

Aluminum Rod

batch:

M 101655

BE 06-08-28

8-Grind welds flush as per Dwg D2750

9-Spot face ground handling holes section J-J (total of 4 places per side) as per dwg D2750

10-Deburr holes

Prs  
06-08-16

6-8-28

W/O:		WORK ORDER CHANGES					
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Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC5/9

WELD INSPECTION



Comment: Inspect weld and work to Step 20

*06-08-30 (1)*

*PD 06-08-30 (1)*

14.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (Ref. 4.3.5.1) as per Dart QSI 005 4.3

*a.m 06-09-05*

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Inspect for foreign object per QSI 024

*DL 06/09/06 (1)*

16.0

NAS1330S3KB166

INSERT



Comment: Qty.: ~~38.0000~~ Each(s)/Unit Total: 38.0000 Each(s)

INSERT

Batch: *m 101715 (38X)*

*a.m 06-09-06 (1)*

17.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install inserts as per Dwg D2750

*a.m 06-09-06 (1)*

18.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Inspect Inserts

*M 06 09 06 (1)*

19.0

D26483

Wearpad



Comment: Qty.: 5.0000 Each(s)/Unit Total: 5.0000 Each(s)

Wearpad

Batch: *B 27169-2*

20.0

D265613

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Wearplate

Batch: *B 27074*

*a.m 06-09-06 (1)*

W/O:		WORK ORDER CHANGES					
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Job Number: 27957

Part Number: D350636011

Job Number:



Seq. #:	Machine Or Operation:	Description :
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21.0	D265635	Wearplate
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearplate

Batch: 1325330

22.0	D2746	Wearshoe
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearplate

Batch: B27485

23.0	D2745	Bushing
------	-------	---------



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bushing

Batch: 27862

24.0	D3488041	BLADE FITTING ASSEMBLY, LH
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Blade Fitting, LH

Batch: B26838

25.0	D3492041	PLUG ASSEMBLY
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

PLUG ASSEMBLY

Batch: 27518

26.0	D3492043	PLUG ASSEMBLY
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

PLUG ASSEMBLY

Batch: 29024

W/O:		WORK ORDER CHANGES					
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Job Number: 27957

Part Number: D350636011

Job Number:



Seq. #:	Machine Or Operation:	Description :
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27.0	AN3C5A	Bolt
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Comment: Qty.: 38.0000 Each(s)/Unit Total : 38.0000 Each(s)

Bolt

Batch: 101938

28.0	AN3C6A	BOLT
------	--------	------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: 19522

29.0	AN3C7A	BOLT
------	--------	------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

BOLT

Batch: 10124

30.0	AN6C44A	BOLT
------	---------	------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

BOLT

Batch: 101943

31.0	AN8C35A	BOLT
------	---------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BOLT

Batch: 102180

32.0	AN960C10L	washer
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Comment: Qty.: 46.0000 Each(s)/Unit Total : 46.0000 Each(s)

washer

Batch: 101340

33.0	AN960C816L	WASHER
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

Batch: 100186

W/O:		WORK ORDER CHANGES					
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Job Number: 27957

Part Number: D350636011

Job Number:



Seq. #:

Machine Or Operation:

Description :

34.0

MS210436

NUT



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

NUT

Batch: 101537

35.0

MS21083C8

NUT



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

NUT

Batch: 100186

36.0

NAS1515H3L

WASHER



Comment: Qty.: 46.0000 Each(s)/Unit Total: 46.0000 Each(s)

WASHER

Batch: 101418

37.0

NAS1515H8L

WASHER



Comment: Qty.: 10.0000 Each(s)/Unit Total: 10.0000 Each(s)

WASHER

Batch: 100187

38.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Inspect for Foreign Objects

2-Spray inside of tube with "LPS-3" batch: 101915

3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750

SIKA FLEX 241

BATCH: 102107

EXP DATE: 02/07

4-Coat all exposed fasteners with "LPS Procyon" batch: 17168

Q.M./FC 06 11 13 ①

W/O:		WORK ORDER CHANGES					
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Job Number: 27957

Part Number: D350636011

Job Number:



Seq. #:

Machine Or Operation:

Description :

39.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

1006/11/13 ①

40.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

41.0

D2741

Blade



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Blade

Batch: 027968 ✓

42.0

AN960C816L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: M100186 ✓

43.0

MS21083C8

NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Batch: M100186 ✓

44.0

AN8C21A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M100262 ✓

45.0

NAS1515H8L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

Batch: M102515 ✓

1006/11/13

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/11/15

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



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Job Number: 27957

Part Number: D350636011

Job Number:



Seq. #:

Machine Or Operation:

Description:

46.0

D34931

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

WASHER

Batch: B27895x1, B27835x1-

47.0

D35321

spacer



Comment: Qty.: 2.0000 (s)/Unit Total: 2.0000 (s)

batch: B27894 ✓

AB 06/11/13

48.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

PC 6/11/14 (1)

49.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Package as per PPP D350-636-011

PC R

PC 6/11/14 (1)

50.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

AG 06.11.14

Job Completion



C Loc 11114

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

**DART****RELEASED**  
06-02-07

DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2750	REV. D SHEET 1 OF 5
DATE 06.01.05		TITLE 350 SKIDTUBE ASSEMBLY SCALE NTS	
A	98.04.16	NEW ISSUE	
B	98.09.01	CHANGE MS24694-S293 TO AN8-16A	
C	98.11.18	ADD D2750-3/D2750-4 INCORPORATE D2738 AND D2740	
D	06.01.05	ADD HOLES AND SPACERS FOR APICAL FLOATS INCORPORATE DEO 9133/9157	

Qty -041	Qty -042	Qty -043	Qty -044	Part Number	Description
X				D2750-041	SKIDTUBE ASSEMBLY, LH
	X			D2750-042	SKIDTUBE ASSEMBLY, RH
		X		D2750-043	SKIDTUBE ASSEMBLY, LH
			X	D2750-044	SKIDTUBE ASSEMBLY, RH
5	5	5	5	D2648-3	WEARPAD
1	1	1	1	D2656-13	WEARSHOE
1	1	1	1	D2656-35	WEARSHOE
1	1	1	1	D2746	WEARSHOE
1	1	1	1	D2739	WEB
1	1	1	1	D2741	BLADE
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
38	38	38	38	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN3C7A	BOLT
4	4	4	4	AN6C44A	BOLT
2	2	2	2	AN8C21A	BOLT
1	1	1	1	AN8C35A	BOLT
46	46	46	46	AN960C10L	WASHER
4	4	4	4	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
3	3	3	3	MS21083C8	NUT
42	42	42	42	NAS1330S3KB166	INSERT
46	46	46	46	NAS1515H3L	WASHER
12	12	12	12	NAS1515H8L	WASHER

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO 27957

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DESIGN PH	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED PH	DRAWING NO. D2750	REV. 0 SHEET 2 OF 5
DATE 06.01.05		TITLE 350 SKIDTUBE ASSEMBLY	SCALE NTS

RELEASED  
06.02.07

GENERAL NOTES:

1. ALL DIMENSIONS ARE IN INCHES
2. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
3. MAKE FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
4. DAMAGE TOLERANCE ON BENDING:  
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 12 INCHES ABOVE THE GROUND. NO GOUGING IS ACCEPTABLE IN THE FLAT PORTION OF THE TUBE. GOUGES UP TO 0.020 ARE ACCEPTABLE IN THE BENT PORTION OF THE TUBE. TUBE O.D. SHOULD BE  $3.150 \pm 0.010$  IN THE FLAT PORTION OF THE TUBE. TUBE O.D. SHOULD BE  $3.15 \pm 0.030$  IN THE BENT PORTION OF THE TUBE.
5. ALL HOLES DRILLED ON CENTERLINES EXCEPT THOSE NOTED BY SECTIONS E-E, F-F, AND R-R.
6. WELDING TO BE DONE PER DART QSI 004.
7. FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:  
MINIMUM YIELD TENSILE STRENGTH = 35 ksi  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
8. FINISH:  
ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
9. INSTALL NAS1330S3KB166 INSERTS AFTER FINISH AS INDICATED IN D2750-1/-2/-3/-4 WELDING DETAIL ON PAGE 4 AND 5. DRILL 'E' SIZE HOLES ( $\emptyset 0.250$ -  $\emptyset 0.257$ ) FOR WEARSHOE INSERTS. C'SINK  $\emptyset 0.391 \times 100^\circ$  AND INSTALL INSERTS
10. D3488-041 (OR D3488-042) BLADE FITTING AND AN3-5A/AN3-7A WEARSHOE SCREWS TO BE INSTALLED USING SIKAFLEX-241 (OR EQUIVALENT) SEALANT.
11. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
12. APPLY A LAYER OF SIKAFLEX -241/-291 ADHESIVE BETWEEN THE BOTTOM OF THE SKIDTUBE ASSEMBLY AND THE WEARPLATES

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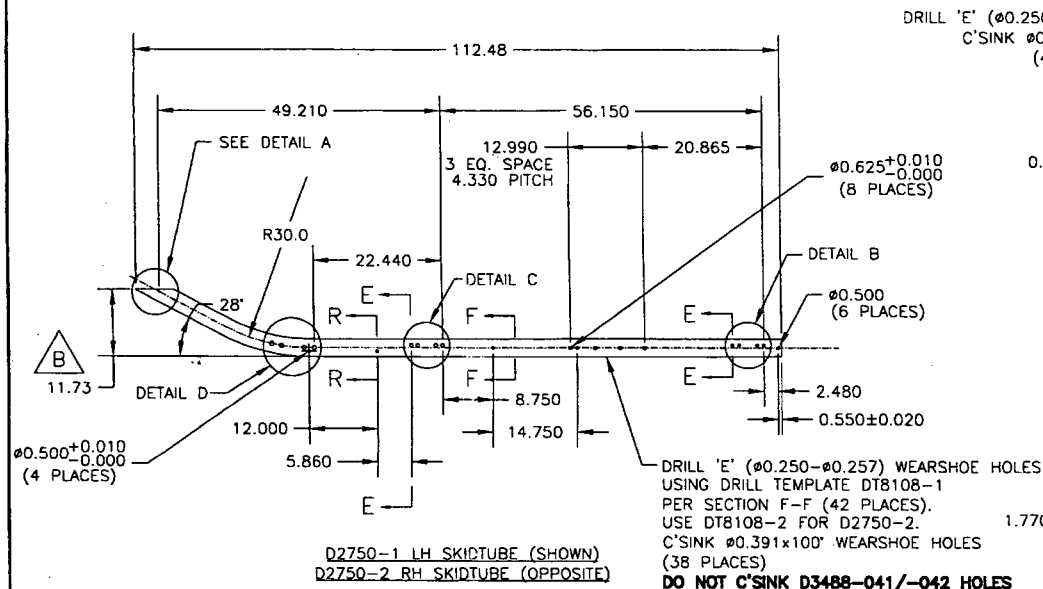
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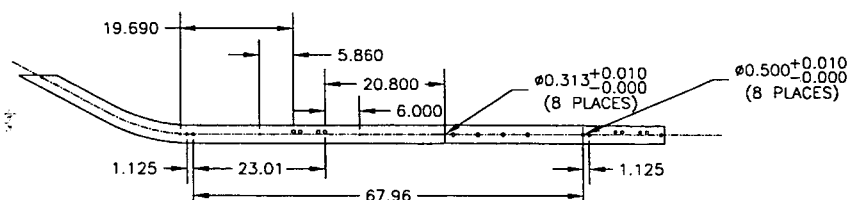
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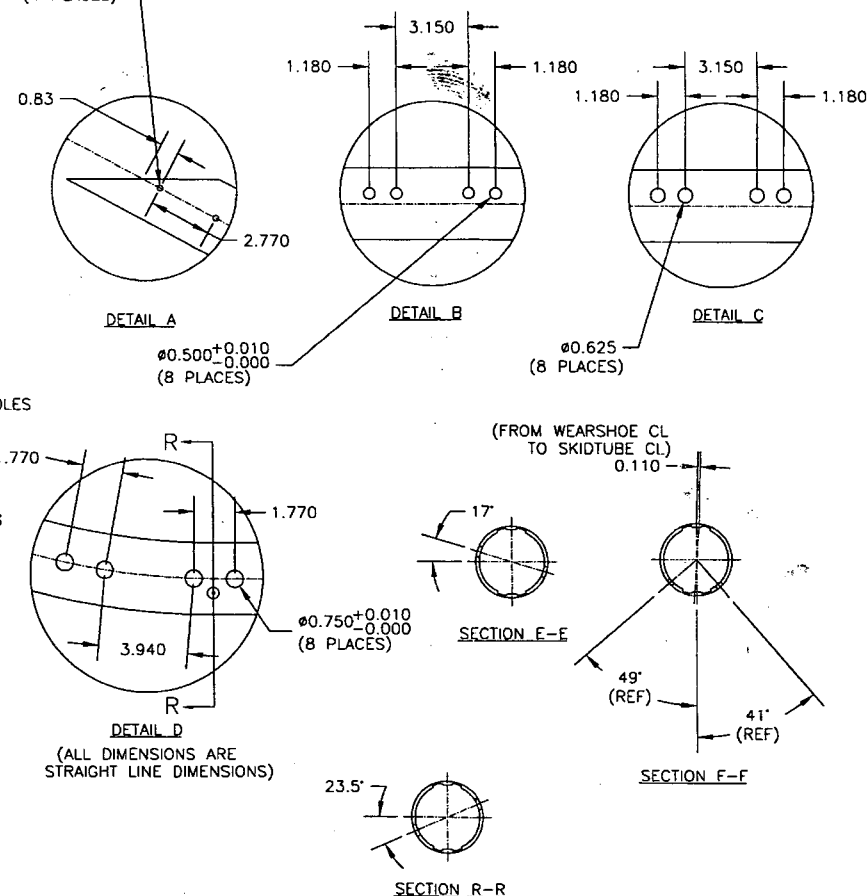
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D2750-1 LH SKIDTUBE (SHOWN)  
D2750-2 RH SKIDTUBE (OPPOSITE)



D2750-3 LH SKIDTUBE (SHOWN)  
D2750-4 RH SKIDTUBE (OPPOSITE)  
D2750-3/-4 AND D2750-1/-2 HAVE THE SAME SADDLE AND  
GROUND HANDLING HOLES

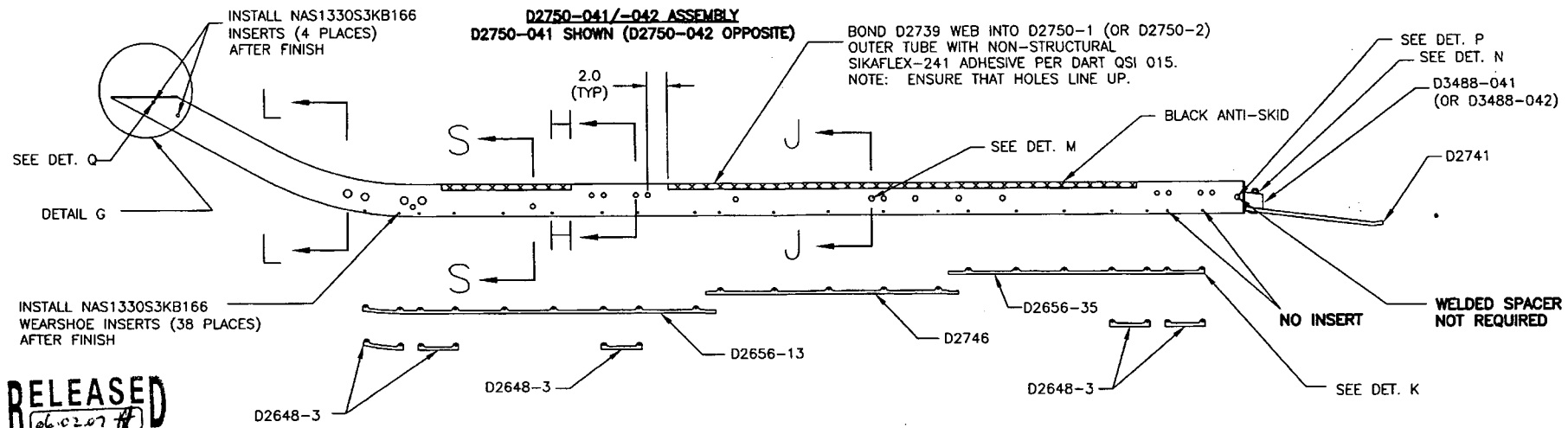


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		DATE	06.01.05			TITLE 350 SKIDTUBE ASSEMBLY	SCALE 1:20

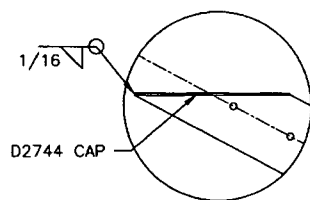
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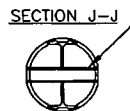
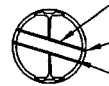
**D2750-041/-042 ASSEMBLY**  
D2750-041 SHOWN (D2750-042 OPPOSITE)



**DETAIL G**



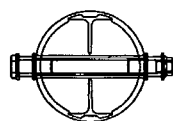
**SECTION H-H**



**WELDING INSTRUCTIONS**

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2743 SPACER
3. WELD INTO PLACE
4. GRIND FLUSH
5. DRILL OUT SPACER TO Ø0.484
6. SPOT FACE Ø0.750 (SECTION J-J ONLY)

**DETAIL M**

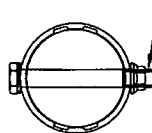


**DETAIL K**

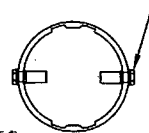


- AN3C5A BOLT (1)
- AN960JD10L WASHER (1)
- NAS1515H3L WASHER (1)
- (38 PLACES)

**DETAIL P**



**DETAIL Q**



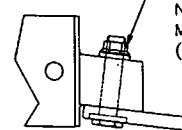
**SECTION L-L**

D3490-3 SPACER

Ø0.750 HOLES ONLY

D3492-043 PLUG ASSEMBLY

**DETAIL N**



**SECTION S-S**

D3490-1 SPACER

Ø0.500 HOLES ONLY

D3492-041 PLUG ASSEMBLY

**WELDING INSTRUCTIONS**

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D3490-1 SPACER (4 PLACES) INTO Ø0.500 HOLES OR INSERT D3490-3 SPACER (4 PLACES) INTO Ø0.750 HOLES
3. WELD INTO PLACE
4. GRIND FLUSH
5. INSERT D3492-041 PLUG ASSEMBLY (8 PLACES) INTO D3490-1 SPACER OR INSERT D3492-043 PLUG ASSEMBLY (8 PLACES) INTO D3490-3 SPACER ON BOTH ENDS

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DART AEROSPACE USA, INC.  
PORT HADLOCK, MA

DRAWING NO. D2750

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SHEET 4 OF 5

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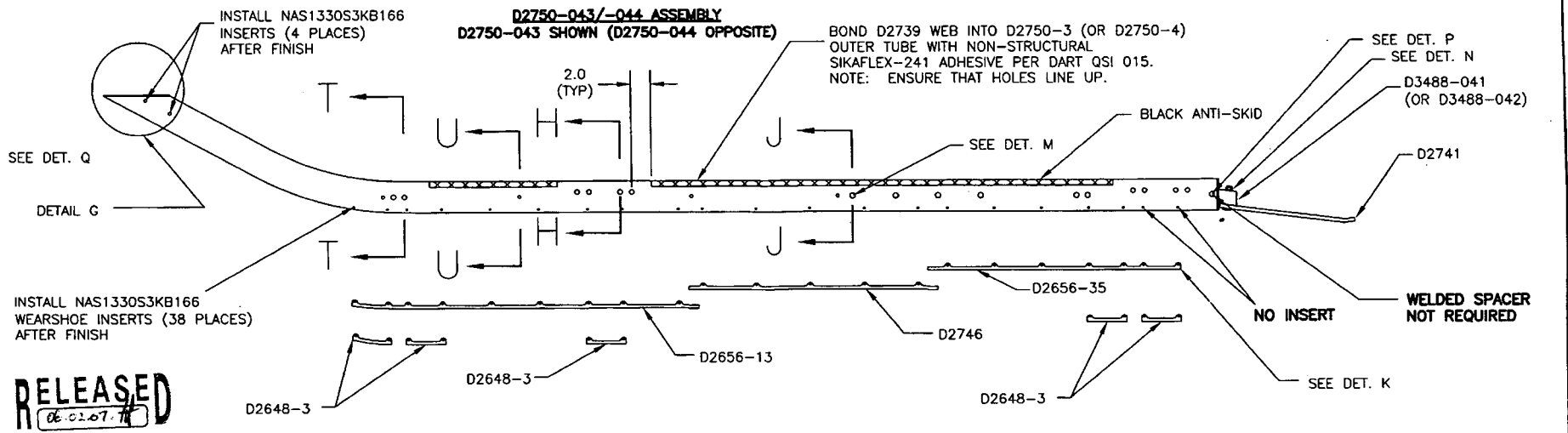
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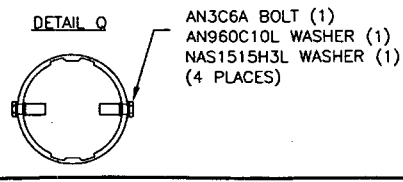
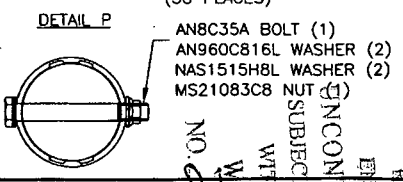
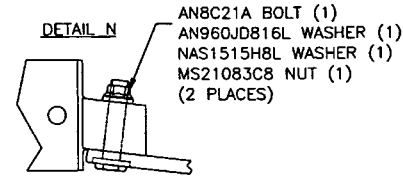
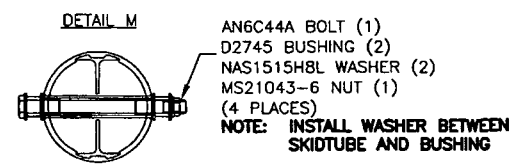
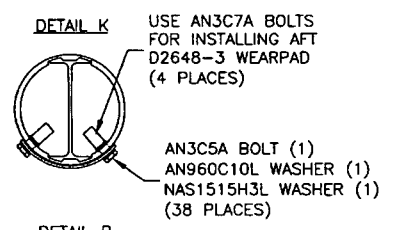
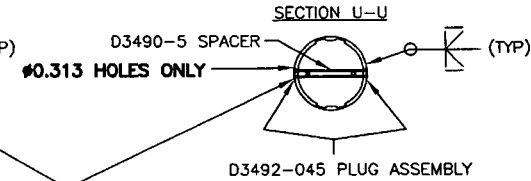
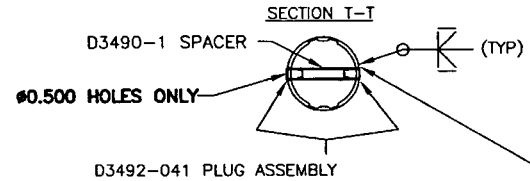
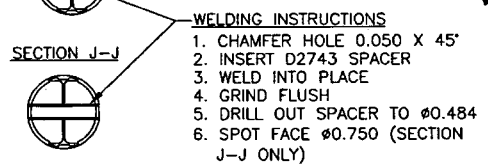
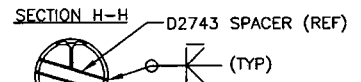
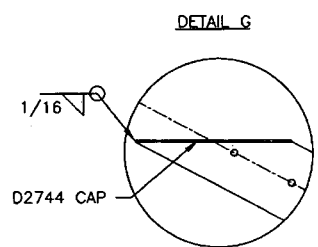
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- WELDING INSTRUCTIONS**
1. CHAMFER HOLE 0.050 X 45°
  2. INSERT D3490-5 SPACER (4 PLACES) INTO Ø0.313 HOLES OR INSERT D3490-1 SPACER (4 PLACES) INTO Ø0.500 HOLES
  3. WELD INTO PLACE
  4. GRIND FLUSH
  5. INSERT D3492-045 PLUG ASSEMBLY (8 PLACES) INTO D3490-5 SPACER OR INSERT D3492-041 PLUG ASSEMBLY (8 PLACES) INTO D3490-1 SPACER ON BOTH ENDS

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